

Work Order ID 73169

Friday, August 26, 2011 7:15:05 AM



Page 1

Item ID: D3641-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Cover

Start Date: 8/26/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

CA

Date: 11/08/26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3641

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3641

Dwg Rev: *E*

Prog Rev: *C*

2-Deburr if necessary

B11-9-21

(8)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-9-21

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/26/21

(EE)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73169

Friday, August 26, 2011 7:15:05 AM

Page 2

Item ID: D3641-3

Accept

Revision ID:

Item Name: Cover

Start Date: 8/26/2011 Start Qty: 6.00

Required Date: 9/9/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3641-3

0.00

0.00

SB 11/09/27

(8)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

D 11/09/27

(4)

3

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

S d 11/09/27
counter

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73169

Friday, August 26, 2011 7:15:05 AM



Page 3

Item ID: D3641-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Cover

Start Date: 8/26/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 BR 11-9-27.

170

Identify as per dwg & Stock Location: SE 260 . 0.00



Packaging

Memo

0.00

Packaging

8X SP 11-09-28

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/1/28

ME 11-09-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 7:15:02 AM

Page 1

Work Order ID: 73169

Parent Item: D3641-3

Parent Item Name: Cover





Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B ECN 1050 rev.b as per dwg 08-01-10 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.032		Purchased	No			100	sf	98.3000	0.7851	4.958526	6.5		
													
5052-H32 .032 Sheet													
													
B11-9-21													

Location

Loc Qty

Loc Code

MAT022

98.3

100470

2

103321

2

105998

3

108462

5

109478

6

111448

2

112664

16

115638

12

116657

27

117798

23.3

116657

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	73169
Description: Cover		Part Number:	D3641-3
Inspection Dwg: D3641	Rev: B	Page 1 of 1	

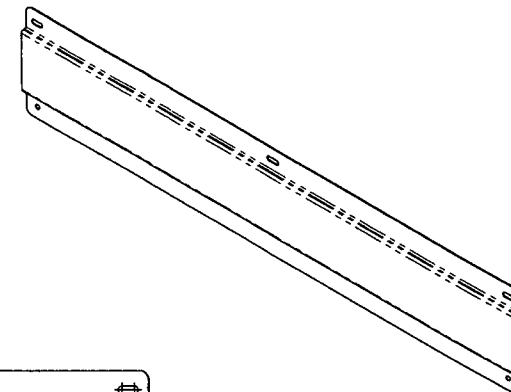
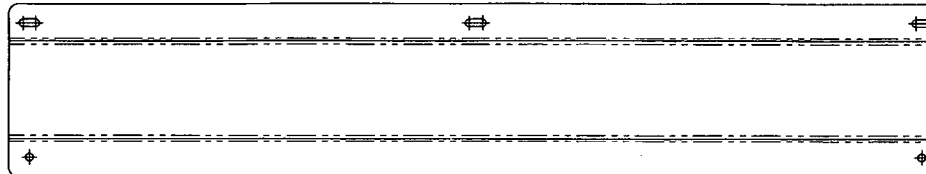
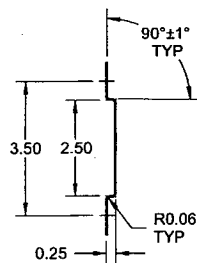
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.001	.191	X		V HB02	
0.50	+/-0.030	.498	2		V	
4.78	+/-0.030	4.785	2		V	
0.84	+/-0.030	.84	1		V	
0.90	+/-0.030	.90	2		V	
12.42	+/-0.030	12.42	1		T B01	
22.42	+/-0.030	22.42	2		T	
24.00	+/-0.030	24.00	8		T	
24.84	+/-0.030	24.84	2		T	

Measured by: AB	Audited by: S	Prototype Approval:	N/A
Date: 11-9-21	Date: 11/9/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.12.01	New Issue	KJ/EC/DD	AS



D3641-1 COVER
(REPLACES GENEVA P/N G10606-3/-6)
 (MAKE FROM D3641-1F FLAT PATTERN)

RELEASED
 2009-11-18

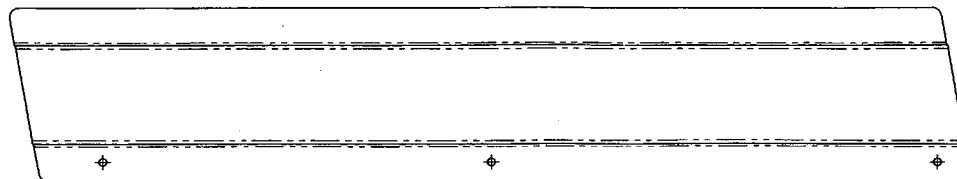
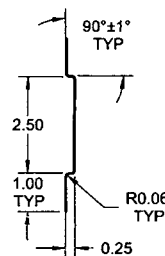
NOTES:

- 1) MATERIAL: D3641-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.35 lbs

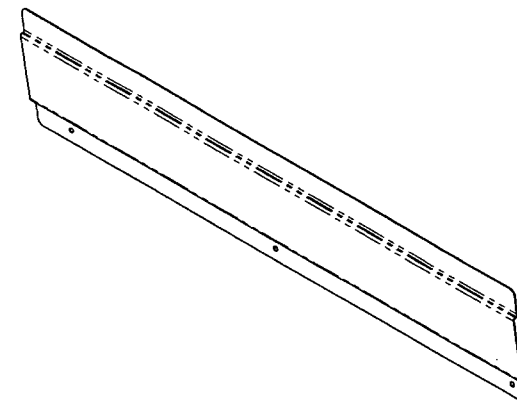
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 73169
CD11108126

C	REFORMAT DRAWING TO CURRENT STANDARDS; D3641-3 WAS -4 (ZN C4-2); ADD D3641-4 VIEW (ZN A4-2); MOVE -1F1-3F FLAT PATTERN TO SHEET 3. PER NCR 09-076	RF	09.10.02
B	UPDATE PROFILE TO MATCH TOOLING; GENERAL UPDATE	LE	07.10.16
A	NEW ISSUE; REPLACES G10606	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3641	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
DATE	09.10.02	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

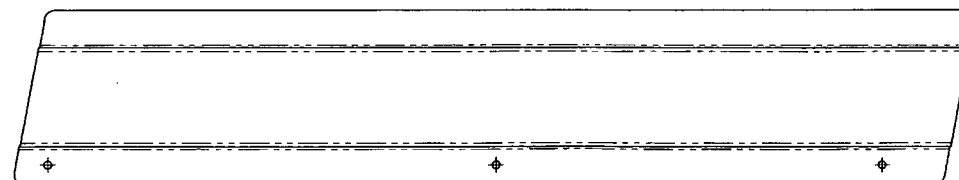
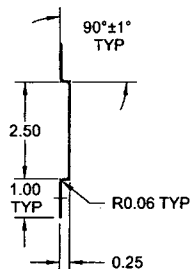
8 7 6 5 4 3 2 1



D3641-3 COVER
(REPLACES GENEVA P/N G10606-5)
(MAKE FROM D3641-3F FLAT PATTERN)



D3641-3 COVER (SHOWN)
D3641-4 COVER (OPPOSITE)



D3641-4 COVER
(REPLACES GENEVA P/N G10606-4)
(MAKE FROM D3641-3F FLAT PATTERN)

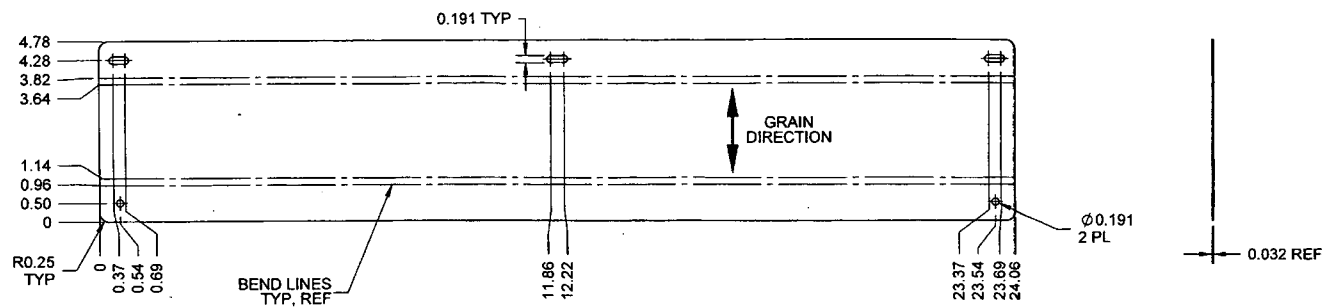
RELEASED
2009 -11- 10

NOTES:

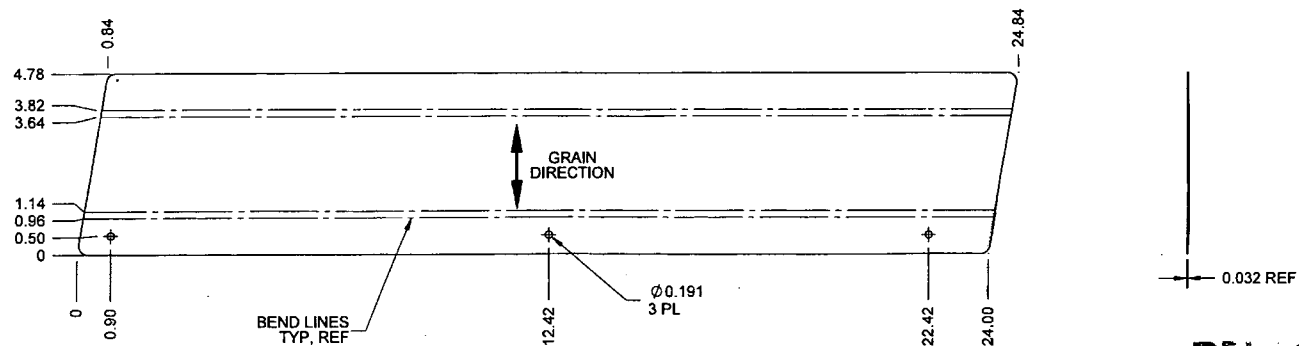
- 1) MATERIAL: D3641-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3641	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
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8 7 6 5 4 3 2 1







D3641-1F FLAT PATTERN



D3641-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 OR ASTM B209
REF DART SPEC M5052H32S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1F/-3F" USING REMOVABLE TAG
- 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3641	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
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RELEASED
2009-11-10